



Dart Aerospace Ltd.
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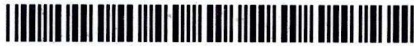
D5350-041
Job Sheet 184910



Part No: D5350-041

Job Qty: 2 ea

Part Name: Fwd Cross Beam Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.25 rev.a dwg DD VERF:JLM IPP REV:C 16.06.30 DWG REV:B DD VERF:JLM IPP REV:D 17.01.09 DWG REV:c DD VERF:JLM IPP REV:E DWG. REV.D 17/04/11 JFS VERIFIED BY: DD

Ship Via:

00 1856

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Machining-4		lin
100	Bandsaw	2 pcs	10/31/18	10/31/18	0.00	0.08	Bandsaw1		lin
110	CNC Vertical Machining	2 pcs	10/31/18	10/31/18	1.26	4.44	HAAS1-2		lin
120	QC	2 pcs	10/31/18	10/31/18	0.00	0.00	QC2 Machining-4		lin
130	Mill Conv	2 pcs	10/31/18	10/31/18	0.00	4.00	Mill Conv 1		lin
140	QC	2 pcs	10/31/18	10/31/18	0.00	0.00	QC8		lin
150	Skidtubes	2 pcs	10/31/18	10/31/18	0.00	0.21	Skidtubes-3		lin
160	QC	2 pcs	10/31/18	10/31/18	0.00	0.00	QC5		lin
170	HandFinish	2 pcs	10/31/18	10/31/18	0.00	0.20	HandFinish1		lin
180	QC	2 pcs	10/31/18	10/31/18	0.00	0.00	QC7-5		lin
190	Powdercoat	2 pcs	10/31/18	10/31/18	0.00	0.20	Powdercoat1		lin
200	QC	2 pcs	10/31/18	10/31/18	0.00	0.00	QC3		lin
210	Small Fab	2 pcs	10/31/18	10/31/18	0.00	0.93	Small Fab-9		lin
220	QC	2 pcs	10/31/18	10/31/18	0.00	0.00	QC5		lin
230	Packaging	2 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-2		lin
240	QC21-SA	2 Ea	10/31/18	10/31/18	0.00	0.00	QC21		lin

M 138551

START: 1:55 OUT: 3:30 FINISH: 2:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	11.5500 ft (5.775 ea)	90-Start up Operation	5123777
AN3-13A	Bolt	4 Ea (2 ea)	210-Small Fab	5098032
CBL-1240	Cable	10.8400 ft (5.42 ea)	210-Small Fab	5113791
CBL-460	Loop Sleeve	20 Ea (10 ea)	210-Small Fab	5148627
D5324-3	Bracket	2 Ea (1 ea)	210-Small Fab	5161326
D5346-3	Bushing	8 Ea (4 ea)	210-Small Fab	5108082X1 513952X15
D5350-5	Adapter	2 Ea (1 ea)	210-Small Fab	5127131
MS17984-C412	Pin, Quick Release	4 Ea (2 ea)	210-Small Fab	4x5123461 5090932X4
MS17984-C418	Quick Release Pin	2 pcs (1 ea)	210-Small Fab	5036480
MS17984-C517	Pin, Quick Release	4 Ea (2 ea)	210-Small Fab	5000375
MS21042L3	Nut	4 Ea (2 ea)	210-Small Fab	5147929
AS1149D0316J	Washer	8 Ea (4 ea)	210-Small Fab	5134502-2



Container No: S129979



Part: D5350-041

Job No: 184910

Serial No/Batch: S129979

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 11/21/16

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	12	48	0
210-Small Fab	AN3-13A	4	97	0
	CBL-1240	11	344	0
	CBL-460	20	393	0
	D5324-3	2	57	0
	D5346-3	8	17	0
	D5350-5	2	11	0
	MS17984-C412	4	15	0
	MS17984-C418	2	29	0
	MS17984-C517	4	38	0
	MS21042L3	4	2,621	0
	NAS1149D0316J	8	584	0

Part Specifications

Specifications could not be found.

Plex 10/18/18 7:32 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	184910
Description: Fwd Beam		Part Number:	D5350-1
Inspection Dwg: D5350 Rev: D		Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	.258	✓		Pin gauge	
0.40	+/-0.030	.402	✓		high gage	
1.00	+/-0.030	1.007	✓		high gage	
1.20	+/-0.030	1.207	✓		high gage	
2.00	+/-0.030	1.999	✓		vernier	
0.65	+/-0.030	.655	✓		vernier	
3.15	+/-0.030	3.149	✓		vernier	
0.716	+0.010/-0.020	.715	✓			
37.20	+/-0.030	37.190	✓		tape	
39.70	+/-0.030	39.70	✓		tape	
0.300	+/-0.010	.295	✓		vernier	
0.25	+/-0.030	.241	✓		vernier	
0.280	+0.015/-0.005	.280	✓		high gage	
12.000	+/-0.005	11.999	✓		vernier 12 place	
9.06	+/-0.030	9.070	✓		vernier 12 place	
0.62	+/-0.030	.615	✓		vernier	
0.80	+/-0.030	.803	✓		vernier	
5.22	+/-0.030	5.202	✓		high gage	
4.05	+/-0.030	4.035	✓		high gage	
2.55	+/-0.030	2.55	✓		high gage	
0.30	+/-0.030	.292	✓		vernier	
0.35	+/-0.030	.341	✓		vernier	
0.750	+/-0.005	.749	✓		vernier	
0.55	+/-0.030	.540	✓		vernier	
1.00	+/-0.030	.999	✓		vernier	
0.550	+/-0.010	.557	✓		vernier	
0.225	+/-0.010	.222	✓		vernier	
Ø0.325	+0.006/-0.001					
1.00	+0.030/-0.000					
0.600	+/-0.005					
0.045 x 45°	+/-0.015 x +/-0.5°	.050 x 45°	✓		vernier	
2.05	+0.030/-0.010	2.049	✓		high gage	
1.030	+0.015/-0.000	1.032	✓		vernier	
0.250	+0.015/-0.010	.251	✓		vernier	
0.480	+/-0.015	.480	✓			
Ø0.375	+0.004/-0.010	.374	✓		Pin gauge	
0.415 x 90°	+/-0.010 x +/-0.5°	.420	✓		vernier	
4.23	+/-0.030	4.223	✓		vernier	
0.30	+/-0.030	.298	✓		vernier	

DART AEROSPACE LTD		Work Order: 184910
Description: Fwd Beam		Part Number: D5350-1
Inspection Dwg: D5350	Rev: D	Page 2 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	.245	✓		vernier	
Ø0.204	+0.005/-0.001	.206	✓		Pin gage	
0.30	+/-0.030	.298	✓		vernier	
2.50	+/-0.030	2.501	✓		vernier	
66.78	+/-0.030	66.775	✓		tape	
0.25	+/-0.030	.248	✓		vernier	
0.51 - 0.45	N/A	.455	✓		vernier	
2.50	+/-0.030	2.502	✓		vernier	
0.50	+/-0.020	.492	✓		vernier	
1.50	+/-0.030	1.500	✓		vernier	
1.30	+/-0.030	1.300	✓		vernier	

Measured by: LMM	Checked by: JML	QC Inspector:
Date: 2018/11/15	Date: 18/11/21	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	17.07.18	New Issue	KJ	



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Process Routings

D5350-041 Operations

Fwd Cross Beam Assembly

	Op No	Operation	Description	Workcenters	Supplier	Type	Weight (lbs)	BOM	Special Comments	Location	
	90	Start up Operation		Start Up Machining-4 (Start Up Machining)		Production	.0000	M6061T6B1.000X06.000			
	100	Bandsaw	Cut blank at 69.300"	Bandsaw1 (Bandsaw)		Production	.0000				
	110	CNC Vertical Machining	1-Machine per folio FB447 (D5350-1) DWG REV: _____ FOLIO REV: _____ 2-Deburr and break all sharp edge as per dwg.	HAAS1-2 (HAAS CNC Vertical Machine)		Production	.0000				
	120	QC		QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)		Production	.0000				
	130	Mill Conv	1- C'SINK BOTH SIDE AS PER DWG. DETAIL C. 2- TRIM EDGE AS PER SECTION G-G.	Conv Mill 1 (Manufacture as per dwg)		Production	.0000				
	140	QC		QC8 (QC8- Inspect parts - second check)		Production	.0000				
	150	Skidtubes	DRILL HOLES IN SECTION E-E AS PER DWG BY USING DT10299	Skidtubes-3 (Skidtubes)		Production	.0000				
	160	QC		QC5 (QC5- Inspect part completeness to step on W/O)		Production	.0000				
	170	HandFinish		HandFinish1 (Chemical Conversion Coat per QSI005 4.1)		Production	.0000				
	180	QC		QC7-5 (QC7- Inspect Chemical Conversion Coat)		Production	.0000				
	190	Powdercoat	MASK HOLES AS PER NOTE 8 SHEET 3 START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	Powdercoat1 (White Gloss (Ref:4.3.5.1) per QSI005 4.3-Alum)		Production	.0000				
	200	QC		QC3 (QC3- Inspect Part Finish)		Production	.0000				

D5350-041 Operations

Fwd Cross Beam Assembly

Op No	Operation	Description	Workcenters	Supplier	Type	Weight (lbs)	BOM	Special Comments	Location
210	Small Fab	ASSEMBLE AS PER DWG. D5350-041 (see notes)	Small Fab-9 (Small Fab)		Production	.0000	AN3-13A CBL-1240 CBL-460 D5324-3 D5346-3 D5350-5 MS17984-C412 MS17984-C418 MS17984-C517 MS21042L3 NAS1149D0316J		
220	QC		QC5 (QC5-Inspect part completeness to step on W/O)		Production	.0000			
230	Packaging		Packaging3-2 (Identify as per dwg & Stock Location:)		Production	.0000			ST260B
240	QC21-SA		QC21 (QC21-Final Inspection - Work Order Release)		Production	.0000			ST260B